

Work Order ID 65906

Thursday, January 27, 2011 9:22:33 AM



Page 1

Item ID: D4021-9	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Bushing					
Start Date: 1/28/2011	Start Qty: 24.00		Cust Item ID:		
Required Date: 2/3/2011	Req'd Qty: 24.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>MF</u>	Date: <u>11-01-27</u>	Tooling:	Date:	Run	Start	
QC:		Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4021	B								

100	0.00	<u>11.2.1</u>	<u>27</u>
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Hardinge

Hardinge CNC Lathe Small

Memo

TURN AS PER FOLIO FA 868 AND DWG D4021

DWG REV: B

FOLIO REV: AA

***MACHINE TO .375" MAX OD ***

DEBURR

110	QC2- Inspect parts off machine FAI/FAIB	0.00	<u>11.2.1</u>	<u>27</u>
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QC

Quality Control

Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4021-9

Accept



Setup Start



Revision ID:

Item Name: Bushing

Stop



Start Date: 1/28/2011 Start Qty: 24.00



Cust Item ID:

Required Date: 2/3/2011 Req'd Qty: 24.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

WA 11/2/12

27

130

Identify as per dwg & Stock Location: *WA*

0.00



Packaging

Memo

0.00

Packaging

SAD 11-02-02

27

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/03

ME 11-02-02

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, January 27, 2011 9:22:29 AM

Page 1

Work Order ID: 65906



Parent Item: D4021-9



Parent Item Name: Bushing

Start Date: 1/28/2011

Required Date: 2/3/2011

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP REV:A NEW ISSUE 09-11-23 JLM VERIFIED BY:DD IPP
Rev:B as per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as
per dwg revB DD 10.04.20 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304R.500

Purchased

No

100

f

42.1100

0.083

2.096842



304 SS roundbar .500



11.2.1

Location

Loc Qty

Loc Code

MAT

38.6

115334

38.6

MAT029

3.51

113006

3.51

1.7

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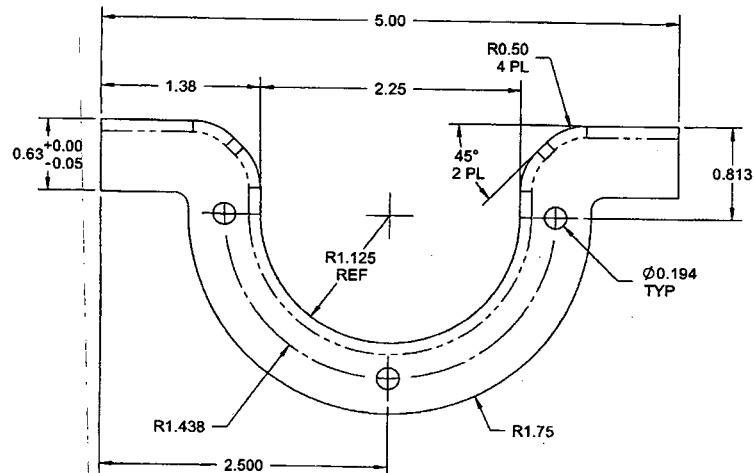
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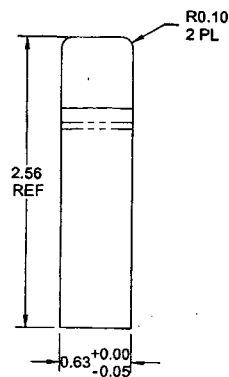
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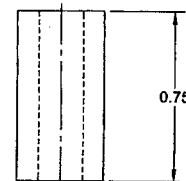
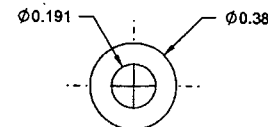
NOTE: Date & initial all entries



D4021-7 HOOP



D4021-9 BUSHING






#65906

RELEASED
2010-04-14
MP

NOTES:

- 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B
- 9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -7: 0.80 lbs
-9: 0.02 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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